

Claims

1. A method for producing thin areas in injection-molded objects, the method comprising the steps:
  - 5 - injecting the thermoplastic polymeric molding mass in the cavity of an injection molding tool;
  - pushing at least one movable core into the cavity while the molding mass is still capable of flowing, whereby the distance between a front face of the core and an opposing
  - 10 surface is reduced to a gap width, in order to create an area of reduced thickness of the molded object.
2. The method of claim 1, wherein the injection pressure
- 15 applied for injecting the molding mass is measured, and the movable core is pushed in when a predetermined increase of the injection pressure is observed and/or the injection pressure exceeds a predetermined value.
- 20 3. The method of claim 1, wherein the core is pushed in approximately 0.5 to 1 second after the injection of the molding mass into the cavity of the tool has begun.
4. The method of claim 1, wherein the molding mass is one
- 25 of polyethylene, polypropylene.
5. The method of claim 4, wherein the molding mass is high-density polyethylene (HDPE).
- 30 6. The method of claim 1, wherein the gap width is equal to or smaller than 0.1 mm
7. The method of claim 6, wherein the gap width is equal to or smaller than 0.08 mm

8. The method of claim 6, wherein the gap width is 0.02 mm or more.

9. The method of claim 8, wherein the gap width is 0.03 mm or more.

10. The method of claim 1, wherein a second movable core, having a front face substantially opposing the front face of the movable core, is moved towards the movable core so that the gap is built substantially between the front faces of the two cores.

11. An injection molding tool comprising at least one movable core, the core being moveable into the cavity of the tool to a position where, between the front face of the core and a wall of the cavity or another core, a gap of a width of at most 0.1 mm is produced.

12. The injection molding tool of claim 11, wherein the gap width is at least 0.02 mm.

13. The injection molding tool of claim 11, wherein the gap width is at most 0.08 mm.

14. An object produced by the method of claim 1, provided with at least one thin area of reduced thickness and substantial extension where the wall thickness is at most 0.1 mm, wherein the thin area is an integral part of the surrounding portion of the object.

15. The object of claim 14, wherein the wall thickness of the thin area is at most 0.08 mm.

16. The object of claim 14, wherein the wall thickness of the thin area is at least 0.02 mm.

17. The object of claim 16, wherein the wall thickness of the thin area is at least 0.03 mm.

5 18. A hanger for a dosimeter with a virtual opening for providing a window of practically unrestricted by absorption passage to radiation, the hanger consisting of polymeric material, and the window being an integral part of the surrounding portion of the hanger and having a thickness  
10 less than or equal 0.1 mm

19. The housing of claim 18, wherein the window has a thickness of at least 0.02 mm.

15 20. The housing of claim 18, consisting of one piece.

21. The housing of claim 18, wherein the window has a thickness of about 0.07 mm to 0.08 mm.

20 22. The housing of claim 18, wherein the window has a thickness of at least 0.03 mm.

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